

Work Order ID 142008

142008

Page 1

Tuesday, February 23, 2016 11:26:39 AM

Item ID: D6101-005 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Billet
Start Date: 2/23/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: MCS Date: FEB 23 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6101	Rev B

100	PURCHASING	0.00							DAS 13 9-89
-----	------------	------	--	--	--	--	--	--	-------------------

100

Purchasing

Purchasing

Memo

Issue P/O: 31480

- a) Description: Aluminum billet
- b) 5.00" x 8.250" x 2.50" thick
- c) Tolerance on all dimensions are +0.030"/-0.000"
- d) Grain direction along 5.00" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

110

Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure material certification is attached

20x 80/6 05-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 142008

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142008

Page 2

Item ID: D6101-005 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Billet
Start Date: 2/23/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				20	0		DAS 14 9-30 16/03/22
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6101								
130	Identify as per dwg & Stock Location: MAT041	0.00				20	0		DAS 14 9-30 16/03/22
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT041								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

MLJ MAR 2 2 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐							
Misidentified ☐	☐	Past Due ☐	OTHER : _____						

Picklist Print

Tuesday, February 23, 2016 11:26:41 AM

Page 1
1

Work Order ID: 142008

142008

Parent Item: D6101-005

D6101-005

Parent Item Name: Saddle Billet

Start Date: 2/23/2016

Required Date: 3/11/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: 01.05.04New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-005P		Purchased	No			110	Each	0.0000	1	20			
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D6101-005P

7075-T7351 8.25X5.0X2.5

20 x SP 16-03-21

DQA: _____ Date: _____



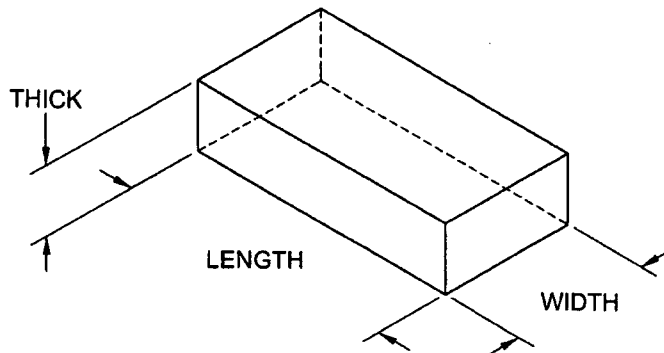
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

STOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 152208 MJS
 16-03-23

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31480

Purchase Order Date 2/24/2016

PO Print Date 2/24/2016

Page Number 1 of 3

Order From :

VU-MET002

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

FEB 24 2016

Contact Name
Vendor Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6101-003P	7075-T7351 2X6.25X7.875	3/11/2016 Yes 3/11/2016		20.00 Each	\$35.29	\$705.80
AS PER DWG D6101 REV. B B142007 SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"							
Line Total:							\$705.80
2	D6101-005P	7075-T7351 8.25X5.0X2.5	3/11/2016 Yes 3/11/2016		20.00 Each	\$36.20	\$724.00
AS PER DWG.D6101 REV.B B142008 SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00"" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"							

8816-03-20

Note:

2/24/2016

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2917821

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 17-MAR-16	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2917821-2	

Shipment Details	Final Destination Branch - TOR
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Order No 4265723	Line No 2	Item No 752241:MO	Description 2.5000.PL.7075.T7351.ALUMINUM.US1.48.5000.144.5000 CUT RECTANGLE TO 8.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 5")) X 5 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 5")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12				
Purchase Order No 31480		Part Number YOUR ITEM NUMBER: D6101-005	Ordered Qty 20.00 PCS			Invoice Qty 20.00 PCS	
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
120361435				10			106.6560
120361435	KAISER ALUMINUM			10			106.6560

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 17-MAR-2016 05:13:01 PM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:



Name:

MAR 17 2016

SHIP TO:

A M CASTLE & CO
3050 SOUTH HYDRAULIC
WICHITA, KS 67216

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CERTIFIED TEST REPORT

Serial Number
4393427

CUSTOMER PO NUMBER: 340208		WORK PACKAGE:		CUSTOMER PART NUMBER: <u>752241</u>		SHIP RUN/LOAD: 103354/19		GOVT CONTRACT NUMBER:	
KAISER ORDER NO: 1197054	LINE ITEM: 1	SHIP DATE: 12-OCT-2015	ALLOY: <u>7075</u>	CLAD: BARE	TEMPER: <u>T7351</u>	PRODUCT DESCRIPTION: KaiserSelect Plate			
WEIGHT SHIPPED: 3618 LB	QUANTITY: 2 PCS EST.	TRUCK B/L #: 2056425	GAGE: <u>2.5000 IN</u> (63.5000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)		LENGTH: 144.500 IN (3670.3 MM)			

MHU 1937229: LOT 154070B7: 2 pieces;

Certified Specifications

DAS
14
9-39

16/03/22

AMS 4078/RevJ
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
MMS 159/RevT

AMS-QQ-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevU
GAMPS 9101/RevB/AmdSCN1
PS 21211/RevM

AMS-STD-2154/RevA
BAC 5439/RevJ
CSTI 008/RevE
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 154070B7 Cast 874

Drop 59

Ingot 2

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:

Temper
T7351

Dir / # Tests

LT / 2 (Min:Max)

Ultimate KSI (MPA)

68.8 : 69.1

(474 : 476)

Yield KSI (MPA)

57.5 : 57.8

(396 : 399)

Elongation %

12.4 : 12.8

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :

41.0 Min

41.1 Max

(MS/M) :

23.8 Min

23.8 Max

(ASTM E1251)

Chemistry:

Actual(wt%)

SI

0.06

FE

0.14

CU

1.4

MN

0.06

MG

2.4

CR

0.19

ZN

5.9

TI

0.02

V

0.01

ZR

0.02

OTHER

TOT 0.05





Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4393427

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	8.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-154138 R 6
AMS 4078, AMS QQ-A-250/12, AMS STD-2154, A
STM B209, ASTM B594, BS
S 7055, CMMP 025, CSTI 006, DPS 4.713, GAMP
S 9101, MMS 159, PS 212

11

TEST NOTES

Metal represented by this test report was 100% immersion ultrasonically tested from one side with 3mm dead zones top and bottom and meets the Class A and Class B requirements of all specifications referenced on this test report. No surface marking of sonic indications is performed.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO-9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
- was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America; and meets the requirements of DFARS 252.225 for domestic content.
- has been thermally processed in compliance with AMS 2772, where applicable.
- is mercury free, within the limits of detection of ASTM E1251 (≤ 1 ppm).
- is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, ECI n°1907/2006.
- is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under law.

JAMES HEMENWAY, LABORATORIES SUPERVISOR





www.abf.com

XXXXCANZ



CORR = A

SHIPPER'S NO. 2903324-2 CRN SEE BELOW

03/17/16 05:50

PAGE 1 OF 2

PICK UP DATE 03/14/16	CODE TO 339D	PO. NO. SEE BELOW	NO. OF P.O.'S 003079-150A	ROUTING LBH-TOR	FREIGHT BILL NO. 161519341A
SHIPPER AM CASTLE & CO 14001 ORANGE AVENUE PARAMOUNT CA 90723				CONSIGNEE AM CASTLE & CO 2150 ARGENTIA RD MISSISSAUGA ON L5N2K7 CA	

PIECES 1 CRT	DESCRIPTION *NOTES FOLLOW: *ALL LOADS MUST BE TARPED *Tarped Flat Deck City Delivery *location. Over 400 pounds and 8' *long require flat deck delivery. *Load long bars on wood *pallet for delivery. *CCN:2604PARS161519341A *TRAN:10348118156246 TOTAL IND PIECES: 1 BARS OR RODS, NOI, BRASS, BRONZE, CADMIUM OR COPPER COATED, IN PKG, CL 50 ITEM 104380-00 / CALIFORNIA COMPLIANCE SURCHARGE / CROSS-BORDER ADMINISTRATIVE FEE TO CLEAR SHORTAGE OF ORIGINAL PRO	WEIGHT (LBS.) 505	RATE CCS CUAF CLR	CHARGES RECEIVED SUBJECT TO COUNT AND INSPECTION MAR 17 2016 A.M. CASTLE & CO. TORONTO
BILL TO A M CASTLE CO SEPARATE INVOICE TO BE MAILED		COD AMOUNT 003079-*	PAY THIS AMOUNT TAR CCZ9910 OZIP 90723 DZIP L5N2K7 SPEC. HAND.	
REMIT TO CUBE 0030 DELIVERY DUE MON 03/21 DELIVERY DATE DRIVER		YOUR ACCEPTANCE OF DELIVERY IS SUBJECT TO ABF 111 SERIES TERMS. X BY (CUSTOMER'S SIGNATURE)		



www.abf.com

XXXXCANZ



CORR = A

SHIPPER'S NO. 2903324-2 CRN SEE BELOW

03/17/16 05:50

PAGE 2 OF 2

PICK UP DATE 03/14/16	CODE TO 339D	PO. NO. SEE BELOW	NO. OF P.O.'S 003079-150A	ROUTING LBH-TOR	FREIGHT BILL NO. 161519341A
SHIPPER AM CASTLE & CO 14001 ORANGE AVENUE PARAMOUNT CA 90723				CONSIGNEE AM CASTLE & CO 2150 ARGENTIA RD MISSISSAUGA ON L5N2K7 CA	

PIECES 1	DESCRIPTION // FUEL SURCHARGE // GOODS & SERVICES TAX // #02/AUTH:Reweigh - See W&R // certificate for details.// CRN: 1111714716 CRN: 4265723 CRN: 4269259 CRN: 4271418 PO: A010110330 PCS 1 WEIGHT LB PO: CC18594 PO: 166109 PO: 31480 ABF MEASURED CUBE: 30.000 CUFT GST NO. R122414626 - ZERO RATED TOTALS FREIGHT BILL NO 161519341A	WEIGHT (LBS.) 505	RATE FSC GST	CHARGES
BILL TO A M CASTLE CO SEPARATE INVOICE TO BE MAILED		COD AMOUNT 003079-*	PAY THIS AMOUNT TAR CCZ9910 OZIP 90723 DZIP L5N2K7 SPEC. HAND.	
REMIT TO CUBE 0030 DELIVERY DUE MON 03/21 DELIVERY DATE DRIVER		YOUR ACCEPTANCE OF DELIVERY IS SUBJECT TO ABF 111 SERIES TERMS. X BY (CUSTOMER'S SIGNATURE) CASHIER 479-785-6475 ABF FREIGHT SYSTEM, INC. 15 STRATHEARN AVENUE BRAMPTON ON L6T 4P1		

SHIP TO:

A M CASTLE & CO
14001 ORANGE AVE
P.O. BOX 1402
PARAMOUNT, CA 90723

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4394171

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CUSTOMER PO NUMBER: 340486		WORK PACKAGE: 752241		CUSTOMER PART NUMBER:		SHIP RUN/LOAD: 103361/3		GOV'T CONTRACT NUMBER:			
KAISER ORDER NO: 1197386		LINE ITEM: 1	SHIP DATE: 19-OCT-2015	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: KaiserSelect Plate				
WEIGHT SHIPPED: 3576 LB		QUANTITY: 2 PCS EST.		TRUCK B/L #: 2056506		GAUGE: 2.5000 IN (63.5000 MM)		DIAMETER/WIDTH: 48.500 IN (1231.9 MM)		LENGTH: 144.500 IN (3670.3 MM)	

MHU 1939057: LOT 141821B9: 1 pieces;

MHU 1939063: LOT 14178988: 1 pieces;

DAS

14

9-39

16/03/22

Certified Specifications

AMS 4078/RevJ
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
MMS 159/RevT

AMS-QQ-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevU
GAMPS 9101/RevB/AmdSCN1
PS 21211/RevM

AMS-STD-2154/RevA
BAC 5439/RevJ
CSTI 006/RevE
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 14178988 Cast 850

Drop 23

Ingot 4

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper
T7351

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
70.1 : 70.4
(483 : 485)

Yield KSI (MPA)
59.3 : 59.6
(409 : 411)

Elongation %
11.1 : 11.1

(ASTM E1004)
(EN 2004-1)

Conductivity %IACS : 40.8 Min
(MS/M) : 23.7 Min

40.8 Max
23.7 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.09	0.19	1.5	0.04	2.5	0.20	5.9	0.02	0.01	0.01	TOT 0.05



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CERTIFIED TEST REPORT

Serial Number
4394171

Lot: 141821B9 Cast 850 Drop 21 Ingot 1 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir./# Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	69.6 : 69.6 (480 : 480)	58.9 : 59.0 (406 : 407)	11.0 : 11.3

(ASTM E1004)
(EN 2004-1)
Conductivity %IACS : 40.5 Min 40.6 Max
(MS/M) : 23.5 Min 23.5 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.09	0.21	1.4	0.06	2.5	0.21	5.7	0.02	0.01	0.01	TOT 0.06

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-15413B R 6
AMS 4078,AMS QQ-A-250/12,AMS STD-2154,A
STM 8209,ASTM B594,BS
S 7055,CMMP 025,CSTI 006,DPS 4.713,GAMP
S 9101,MMS 159,PS 212

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TEST NOTES

Metal represented by this test report was 100% immersion
ultrasonically tested from one side with 3mm dead zones top
and bottom and meets the Class A and Class B requirements of
all specifications referenced on this test report. No
surface marking of sonic indications is performed.

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

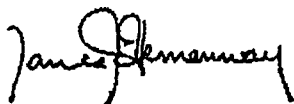
CERTIFIED TEST REPORT

Serial Number
4394171

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO 9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
 - was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.226 for domestic content.
 - has been thermally processed in compliance with AMS 2772, where applicable.
 - is mercury free, within the limits of detection of ASTM E1251 (≤ 1 ppm).
 - is in compliance with RoHS 2, European Union Directive 2011/65/EU.
 - is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
 - is free of Conflict Minerals, as defined in Section 1502 of the Dodd-Frank Act.
- Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.



JAMES HEMENWAY, LABORATORIES SUPERVISOR

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-005
 DATE: 16/03/22

PO / BATCH NO. 31480/142008

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 20
 QUANTITY INSPECTED: 20
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 5.00X8.25X2.50
 THICKNESS RECEIVED: 5.00X8.25X2.50
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	☒	☒	
CORRECT FINISH	☒	☒	
CORROSION	☒	☒	
CORRECT GRAIN DIRECTION	☒	☒	
CORRECT MATERIAL	☒	☒	
CORRECT THICKNESS	☒	☒	
PHOTO REQUIRED	☒	☒	
CORRECT MATERIAL	☒	☒	
CORRECT REF # TO LINK CERT	☒	☒	
CORRECT MATERIAL IDENTIFICATION	☒	☒	
CORRECT M# ON THE MATERIAL	☒	☒	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	☒	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	☒	☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>14</u> DATE: <u>16/03/22</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2 ...) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER